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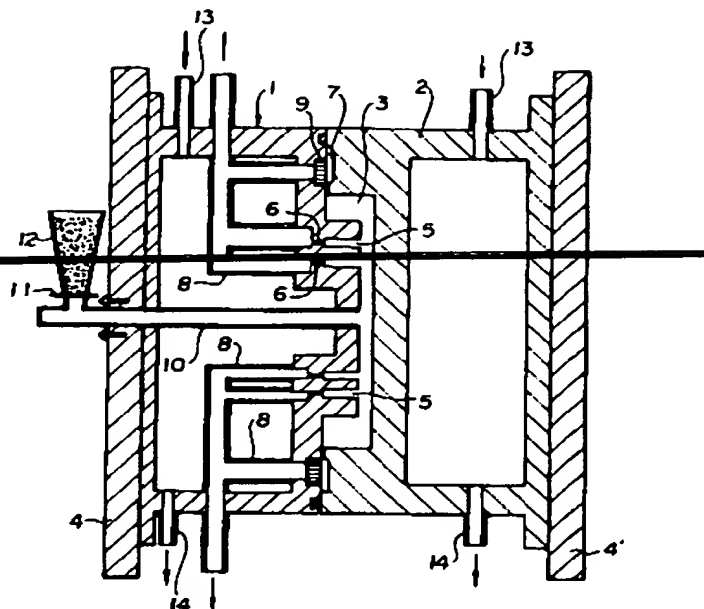
APPLICATION DATE : 20-12-82
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APPLICANT : TOYOTA MOTOR CORP;

INVENTOR : FUKUDA TOKIHARU;

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TITLE : MANUFACTURE OF EXPANDABLE
THERMOPLASTIC RESIN MOLDED
ARTICLE



ABSTRACT : PURPOSE: To manufacture a molded article with fine external appearance at low cost by a method wherein a cavity is vacuumized by sucking the air in the cavity and expandable thermoplastic resin particles are filled in the cavity by the suction force.

CONSTITUTION: A cavity 3 is formed by closing a mold. Expandable resin particles are charged in a hopper and then fed in a pipe 10 by opening a stopper 11. Simultaneously, a suction apparatus is put into operation to produce negative pressure in the cavity 3 in order to suck the expandable resin particles, which is supplied into the pipe 10 by a predetermined amount, from the pipe 10 and to fill them in the cavity 3. Because pipes 8 and venting grooves 7 are fitted to thin parts 5, the complete filling of particles to which is regarded as specially difficult conventionally, and to the corners of the cavity 3 in order to suck the air in the cavity 3 therethrough, no filling failure of resin particles occurs, resulting in producing no rejected part.

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